Tuesday, 09/06/2009 9:21:56 AM

User:

Julie Dawson

Process Sheet

Customer **Job Number** : CU-DAR001 Dart Helicopters Services

: 48429

Estimate Number

: 10404

P.O. Number

This Issue

Prsht Rev.

First Issue

Previous Run

: 09/06/2009

: NC

: // : 47957

Type

S.O. No. :

Part Number

Drawing Name

: D31663

Drawing Number

: D3166 REV A2

: BASKET RIB

Project Number **Drawing Revision**

: N/A : A2

Material **Due Date**

: 15/06/2009

Qty:

6 Um:

Each

Written By **Checked & Approved By**

Comment

: Est. A 02.08.23 New issue KJ

Est Rev:B 09-01-23 as per DEO D3166-A2 DD verified by:EC

: LARGE FAB ASSY

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

304 SQ Tube .75x.75x.065W

M304TS0750W065

Comment: Qty.:

10.1000 f(s)/Unit Total: 60.6000 f(s)

Material: 304/316 SS tube 0.063" wall

(M304TS0750W065)

batch M11205

SKIDTUBESS RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

SKIDTUBES

BENDING

Cut 3/4" x 3/4" square tubing 120.00" long.

BENDING MACHINE - SKIDTUBES

Comment: BENDING MACHINE

Form D3166-3 Basket Hoop as per Dwg D3166 using Bending program 350 BASL, and Folio FT005 1 9-8-17 6

09-06-16

4.0

2.0

3.0

QC6

DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK

Inspect Basket Hoop dimensions with template D3166-3-T1 (DT8303)

5.0

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location: WA 09-06-17

Page 1

Form: rprocess

Dart Aerospace Ltd

		- 							
W/O:			WO	RK ORDER CHANG	ES		<u> </u>		
DATE	STEP	PR	OCEDURE CHAN	IGE	Ву	Date	Date Qty Appr Chief Prod		Approval QC Inspector
Part No: PAR #:		PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	Date:	
Resolution:			Disposition	:	_ QA: N/C Cld	Closed: Date:			
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	ion Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C		QC Inspector
								1	

Date:

Tuesday, 09/06/2009 9:21:56 AM

User:

Julie Dawson

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET RIB

Job Number: 48429

Part Number: D31663

Job Number:

Seq. #:

Machine Or Operation:

Description:

6.0

QC21

Process Sheet

FINAL INSPECTION/W/O RELEASE

mr 09-06-17

Comment: FINAL IN SPECTION/W/O RELEASE

Job Completion



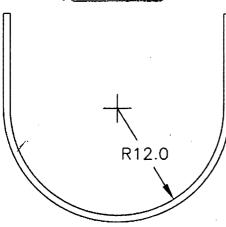
Dart Aerospace Ltd

W/O:			W	ORK ORDER CHANG	GES			·	
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	A: Date:	Approval QC Inspector	
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Part No		PAR #:	Fault Cat		NCR: Yes	s No DQ	A:	Date:	
Resolution:			Dispositi	on:	QA: N/C	Closed:			
NCR:			WORK ORD	DER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng	ction B Sign Dat	∣& _{Sect}	cation ion C	Approval Chief Eng	Approval QC Inspector
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	DESIG	# A	DRAWN BY	DART AEROSPA HAWKESBURY, ONTARIO	
	CHECH	KED	APPROVED	DRAWING NO.	REV. A
	L	#	4	D3166	SHEET 1 OF 1
I	DATE			TITLE	SCALE
	02.0	07.10		BASKET HOOP	NTS
	Α	<u> </u>	02.07.10	NEW ISSUE	
	Al	di	04-04.08	38+1-1 WAS 36.0	



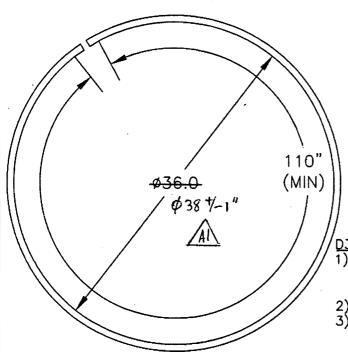
10.6 (REF, NEED 8.0 MIN)

D3166-1 BASKET HOOP

1) MATERIAL: AISI 304/316 SS SQUARE TUBING, 0.75" x 0.75" x 0.063 WALL, 60.00" LONG (REF DART SPEC. M304TS0.750W.063)

2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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D3166-3 BASKET HOOP

1) MATERIAL: AISI 304/316 SS SQUARE TUBING, 0.75" \times 0.75" \times 0.063 WALL, 120.00" LONG (REF DART SPEC. M304TS0.750W.063)

2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:			WO	RK ORDER CHAN	GES			<u> </u>	
DATE	STEP	PRO	OCEDURE CHAN	IGE	В	у	Date Q	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:							
Resolution:		Disposition	Disposition:Q			sed:	Date: _		
NCR:			WORK ORDE	R NON-CONFORM	IANCE (I	NCR)			
DATE	STEP	Description of NC			ction B		Verification	n Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Section C	Chief Eng	QC Inspector

DRAWING NO.	TITLE	, RE	VA1 DART AE	ROSPACE LTD	D.E.O. NO.	SHEET NO.	SCALE
D3166	BASKET HO	OOP	ENGINEE	RING ORDER	D3166-A-2	1 OF 1	NTS
DRAWN	AJS	CHECKED	MFG. APPR.	SA .	APPROVED //	DE APPR	
DATE 0	8.12.11	DATE 08. 12.15	DATE	8/12/15	DATE 08/12/16	DATE 08-12-16	

1) MODIFY MATERIAL NOTE FOR D3166-1 AS SHOWN:

IS:

1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING, 60.00" LONG

REF. DART SPEC M304TS0.750W.065

WAS:

1) MATERIAL: AISI 304/316 SS SQUARE TUBING, 0.75" x 0.75" x 0.063 WALL, 60.00" LONG (REF DART SPEC. M304TS0.750W.063)

2) MODIFY MATERIAL NOTE FOR D3166-3 AS SHOWN:

IS:

1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING, 120.00" LONG
REF. DART SPEC M304TS0.750W.065

WAS:



1) MATERIAL: AISI 304/316 SS SQUARE TUBING, 0.75" x 0.75" x 0.063 WALL, 120.00" LONG (REF DART SPEC. M304TS0.750W.063)

REASON: SEE PAR 08-005

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Dart Aerospace Ltd

	— - 							
		WC	RK ORDER CHANG	ES				
STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			•					
	PAR #:	Fault Cate	Jory:	NCR: Yes	No DQ	A:	Date:	•
Re	solution:	Disposition	_ QA: N/C C	QA: N/C Closed:				
		WORK ORDE	R NON-CONFORMA	NCE (NC	₹)			
STEP	Description of NC						Approval	Approval
	Section A	Chief Eng	Chief Eng			ion C	Chief Eng	QC Inspector
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			All III					
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	: Re	:PAR #: Resolution: STEP Description of NC Section A	STEP PROCEDURE CHAR PROCEDURE CHAR PAR #: Fault Categor Disposition WORK ORDE STEP Description of NC Section A Initial Chief Eng	STEP PROCEDURE CHANGE PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFORMA STEP Description of NC Section A Corrective Action Section Initial Chief Eng Chief Eng Chief Eng	:PAR #:Fault Category:NCR: Yes Resolution:Disposition:QA: N/C C WORK ORDER NON-CONFORMANCE (NCI STEP Description of NC Section A Chief Eng Chief	STEP PROCEDURE CHANGE By Date PAR #: Fault Category: NCR: Yes No DQ Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng/ Prod Mgr PAR #: Fault Category: NCR: Yes No DQA: Date: Disposition: QA: N/C Closed: Date: Date: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Chief Eng Action Description Sign & Date Chief Eng Chief En